Work Orde Wednésday, Octo				*125	5824*							Page	1
Revision ID:	D3650-9 Angle		A	Accept	*N900	<u>)</u> 040	100	ገ*	Setup	Start Stop	IV	S1* S2*	
Start Date: Required Date: Reference:	10/21/14 10/21/14	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item Customer:								
Approvals:		an: MUS	Date: <u> </u>	Tooling: _ SPC (Y/N):		Oate:			Run	Start Stop	"IV	R1* R2*	
Sequence ID/ Work Center ID	U-18 W	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr	Rev	vision Nbr											
D3650	Rev	E											
100 *100 *100 Waterjet FLOW CNC Waterje	t	FLOW WATER JET Memo 1-Cut as per if necessary	r Dwg D3650Dwg Rev:€	0.00 0.00 Prog Rev: &	2-Deburr			(y)			De 14	11/03	DAS 23 9-89
*110 * 1 \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		QC2- Inspect parts off n Memo	nachine FAI/FAIB	0.00				4		<u></u>	Dely	/11/03	DAS 23 9-89
120 *1 20*		QC8- Inspect parts - sec	cond check	0.00				(u))			DAS 38 9-89	_

NOV 0 4 ZU14

Memo

Quality Control

DQA:			. Date:												TQA
						WORK ORDER NON	-C(ONFO	RMANCE / U					<i>ياك</i> ا ^^	EROSPACE
QA Closed:			Date:								Wo	rk Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST	DEP	ARTMENT	/PROCESS		
	-					Rework]	Í	Skid-tube	Crosstube			Water Jet	Engine	eering
Part N	No.					Scrap		i ,	Machining	Small Fab		Pro	d. Eng. Coor.	⊣ -	uality
	-					Use-as-is			noforming	Finishing			re/Packaging	— 1	Other
NCR I	No					Suspected Unapproved			Large Fab	Composite			Supplier]	
Root					Desci	ription of work order update		Initial	Ac	tion		Sign &		<u> </u>	
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	QC II	nspector
Design											Ī				-
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material															
Operator											Ì				
Offset/Setup															
Process	Ш														
Supplier		•													
Training															
Transport			•												
Unapproved														<u> </u>	
							FAI	ULT CAT	EGORY						
Landi						General		1		г				¬ .	
	-	Bending	_		ļ	Bend		Folio/P	rogram		-	Outside Dim	<u> </u>	Pressure/	/Forced
	\vdash	Centre No	ot Concer	ntric		BOM/Route		Grain				Over/Under	⊢	Set-up	
	$\overline{}$	Cracks				Broken/Damage/Defect		Hardwa			_	Part Incorrec		⊣ `	ture/Cure
	-	Crimp/Kin	ık/Ripple,	/Wave		Burrs		1	on Incomplete/Ui		\neg	Part Lost/Mis	ssing	Weld	
	\vdash	Cuffs			-	Contamination		1	ions Incomplete/I	Unclear		Part Moved		_Wrong St	tock Pulled
	_	Crushing				Countersink		1 -	ned/off center			Positioned W	· -	¬	İ
	_	Heat Trea				Cut Too Short		Mislabe		Į	F	Power Loss/S	Surge	Other	
	\vdash	Inspection	· .	Tube		Drawing		Misread							
	-	Marks/Ch				Drill Holes		Off-set							
	$\overline{}$	Turning Se	•		<u> </u>	Finish	igspace	ł	Calibration		_				
	l i	Wave/Tw	ist in Tub	e		Fit/Function		Out of S	equence						

Work Ord Wednesday, Oct		25824 4 12:36:23 PM		*125	824*							Page 2
Item ID:	D3650-9			Accept	*N900	040	100)*	Setup	Start	*N.	S1*
Revision ID: Item Name:	Angle									Stop	*N!	S2*
Start Date:	10/21/14	Start Qty: 4.00	*4*		Cust Item I	D:						
Required Date:	: 10/21/14	Req'd Qty: 4.00	*4*		Customer:							
Reference:							_		Run	Start		
Approvals:	Process Pl	an:	Date:	Tooling:	Da	nte:			2442	Stop	~1/11	R 1*
	QC:		Date:	SPC (Y/N):	Da	nte:				зюр	*NI	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept	t Rej Qty		Reject Number	Insp. Stamp
130		NC DD AVE		0.00			DAS	d				14/1
1 <u>2</u> 0 Brake NC		NC BRAKE Memo		0.00			30 9-89	1				
Brake NC		Form as per	Dwg D3650	,								
140		QC5- Inspect part compl	eteness to step on W/O	0.00			,	(4))			DAS 38 9-89
140 QC Quality Control		Memo		0.00					<u> </u>			NOV 0 6 2

150

Identify as per dwg & Stock Location: 6.A.

0.00

150 Packaging

Memo

0.00

Packaging

4 FF

NOV 0 6 2014

DQA:		Date:			•							
		5.			WORK ORDER NON	-C(ONFO	RMANCE / U				AEROSPACE
QA Closed:		Date:							· · · · · · · · · · · · · · · · · · ·	Work Order u	pdate only	
Work Orde	r:				DISPOSITION				AGAINST [DEPARTMENT	/PROCESS	
				 -	Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	0.				Scrap	1		Machining	Small Fab	⊢ Pro	d. Eng. Coor.	Quality
					Use-as-is	1		noforming	Finishing		re/Packaging	Other
NCR N	o				Suspected Unapproved			Large Fab	Composite		Supplier	
		1	1			T					T	
Root				Desci	ription of work order update	1	Initial		tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Design						ļ						
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material	_											
Operator						ŀ						;
Offset/Setup	_											
Process												
Supplier	_					1						
Training	_											
Transport	_	}										
Unapproved		<u> </u>				<u> </u>						
						FAI	JLT CAT	regory				
Landin T	g Gear				General		l <i>,</i> _		Г	\neg	_	7
-	Bending				Bend	_	1	'rogram	-	Outside Dim	—	Pressure/Forced
-	Centre No	ot Concer	ntric	-	BOM/Route		Grain		<u> </u>	Over/Under	 	Set-up
	Cracks				Broken/Damage/Defect	_	Hardwa		<u> </u>	Part Incorred	 	Temperature/Cure
- "	Crimp/Kir	nk/Ripple	/Wave		Burrs		•	ion Incomplete/Ur	- -	Part Lost/Mi	ssing	Weld
-	Cuffs				Contamination			ions Incomplete/L	Jnclear	Part Moved	<u>L</u>	Wrong Stock Pulled
-	Crushing				Countersink		_	ned/off center	L	Positioned V		-
_	Heat Trea				Cut Too Short	\vdash	Mislabe		Ĺ	Power Loss/	Surge	Other
-	Inspectio	•	Tube		Drawing		Misread	i				
	Marks/Ch				Drill Holes		Off-set					
	Turning S				Finish		i	Calibration				
	Wave/Tw	ist in Tub	e	1	Fit/Function	ı	Out of S	Sequence				

Work Ord		25824 14 12:36:23 PM		*125	5824*							Page 3
Item ID: Revision ID: Item Name:	D3650-9 Angle			Accept	*N900	040	100	/ *	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	10/21/14 10/21/14	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item l Customer:	ID:						
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	^IVI	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	-	Reject Number	Insp. Stamp
*160 *160*		QC21- Final Inspection Memo	Work Order Release	0.00						14/	11/1	04

Quality Control

14/11/10 A) Alpu-11-07

DQA:		Da	te:		<u>-</u>								
QA Closed:		Da	te:		WORK ORDER NON	-C(ONFO	RMANCE / U		W٥	rk Order up	ndate only	AEROSPACE
Q/ Coscu.							<u> </u>				· · · · · · · · · · · · · · · · · · ·		- L
Work Orde	er:				DISPOSITION				AGAINST	DEF	PARTMENT	/PROCESS	
	-				Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	10				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
					Use-as-is		Therr	noforming	Finishing		Rec/Sto	re/Packaging	Other
NCR N	10			· · · · · ·	Suspected Unapproved			Large Fab	Composite			Supplier	
Root				Desc	ription of work order update		Initial	Act	ion	,	Sign &		
Cause	Dat	e Ste	p Q	ty	or non-conformance	1	nief Eng	1	ription		Date	Verification	QC Inspector
Design													
Doc/Data										1			
Equip/Tooling													
Handling/Pre						İ						·	
Material		İ											
Operator													
Offset/Setup													
Process	_			-						ļ			
Supplier													
Training													
Transport	_												
Unapproved													
						FAI	ULT CAT	regory					
Landi	ng Gear				General		,						- -
	Bendi	-		ļ	Bend	`	1	rogram			Outside Dim	ensions	Pressure/Forced
	Centr	e Not Cor	centric	<u> </u>	BOM/Route		Grain				Over/Under	tolerance	Set-up
	Crack				Broken/Damage/Defect	<u> </u>	Hardwa				Part Incorrec	}	Temperature/Cure
		/Kink/Rip	ple/Wa	ive	Burrs	_	Inspecti	on Incomplete/Un	qualified	$\overline{}$	Part Lost/Mi	ssing	Weld
	Cuffs			<u> </u>	Contamination		1	ions Incomplete/U	Inclear		Part Moved		Wrong Stock Pulled
	Crush			<u> </u>	Countersink	_	1	ned/off center		_	Positioned W		
	Heat ⁻				Cut Too Short		Mislabe				Power Loss/S	Surge	Other
		ction Strip	in Tub	e	Drawing		Misread	i		_			
		c/Chatter			Drill Holes		Off-set			_	· · · · · · · · · · · · · · · · · · ·		
		ng Sequer			Finish		1	Calibration		_			
	lWave	/Twist in	Tube	I	Fit/Function	ı	Out of	Sequence					.

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Picklist Print

Wednesday, October 22, 2014 12:36:23 PM

Work Order ID: 125824

125824

Parent Item:

D3650-9

D3650-9

Parent Item Name: Angle

Start Date: 10/21/14

Required Date: 10/21/14

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 07-09-27

IPP Rev;B ECN 1113P 08-01-22

DD verified by: EC DD verified by: EC

IPP Rev:C ecn1162

08-04-02

DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA		Purchased	No			110	sf	270.6890	0.051	0.214737			DAS 23
M304S26	GA								**		D	c 14/11/	9.89

Location	Loc Oty	Loc Code	
MAT020	270.689		
122753	26		
123135	54.689		
m130650	190		.4618

Page 1

DQA:			Date:			WORK ORDER NON	-00	אובטו	DNANCE / I	LIDDATE			DART
QA Closed:			Date:			WORK ORDER NOW	-00	JIVICI	NIVIAINCE /		Work Order u	pdate only	AEROSPACE
Work Orde	er:					DISPOSITION					DEPARTMENT	<u></u>	-
Part N	 lo					Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Desci	ription of work order update		nitial	А	ction	Sign &		
Cause	D	ate	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription	Date	Verification	n QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
							FAL	JLT CAT	EGORY				
Landir	Cen Crac Crim Cuff Crus Hea Insp	cks hp/Kink s hing t Treat ection ks/Cha	Strip in	/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Instructi Misalig Mislabe Misread Off-set	re on Incomplete/I ions Incomplete ned/off center led	/Unclear	Outside Dim Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	tolerance ct issing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
ŀ	_	_	st in Tub	e		Fit/Function	-		equence				

DART AEROSPACE LTD	Work Order:	125824
Description: Angle	Part Number:	D3650-9
Inspection Dwg: D3650 Rev: ₽ = ()		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	. 099	/		V=5kM-01	
0.89	+/-0.030	.89	-		U=5km-08	
1.07	+/-0.030	1.07	1		7=JKMOL	
0.28	+/-0.030	. 293	-			
6.05	+/-0.030	6,055	/			
0.55	+/-0.030	. 55	7			
8.19	+/-0.030	Q. 190	7			
	,					
	DAS					

Measured by:	0.	9-89	Audited by:	DAS 38	Preliminary Approval:
Date:	14/11/	03	Date:	9-89 NOV 0 / 2044	Date:
				140 A () & X() (*)	

Rev	Date	Change	Revised by	Approved
Α	08.04.17	New Issue	KJ/DD ,	11
В	12.09.26	Dwg Rev updated	KJ K	[//
			11)	

